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- Fehrenbach, Jeffrey Arnold  
Cincinnati, Ohio 45255 (US)
- Tomlinson, Thomas John  
West Chester, Ohio 45069 (US)
- Heidorn, Raymond William  
Fairfield, Ohio 45014 (US)
- Crow, John Maynard  
Morrow, Ohio 45152 (US)

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(71) Applicant: **GENERAL ELECTRIC COMPANY**  
Schenectady, NY 12345 (US)

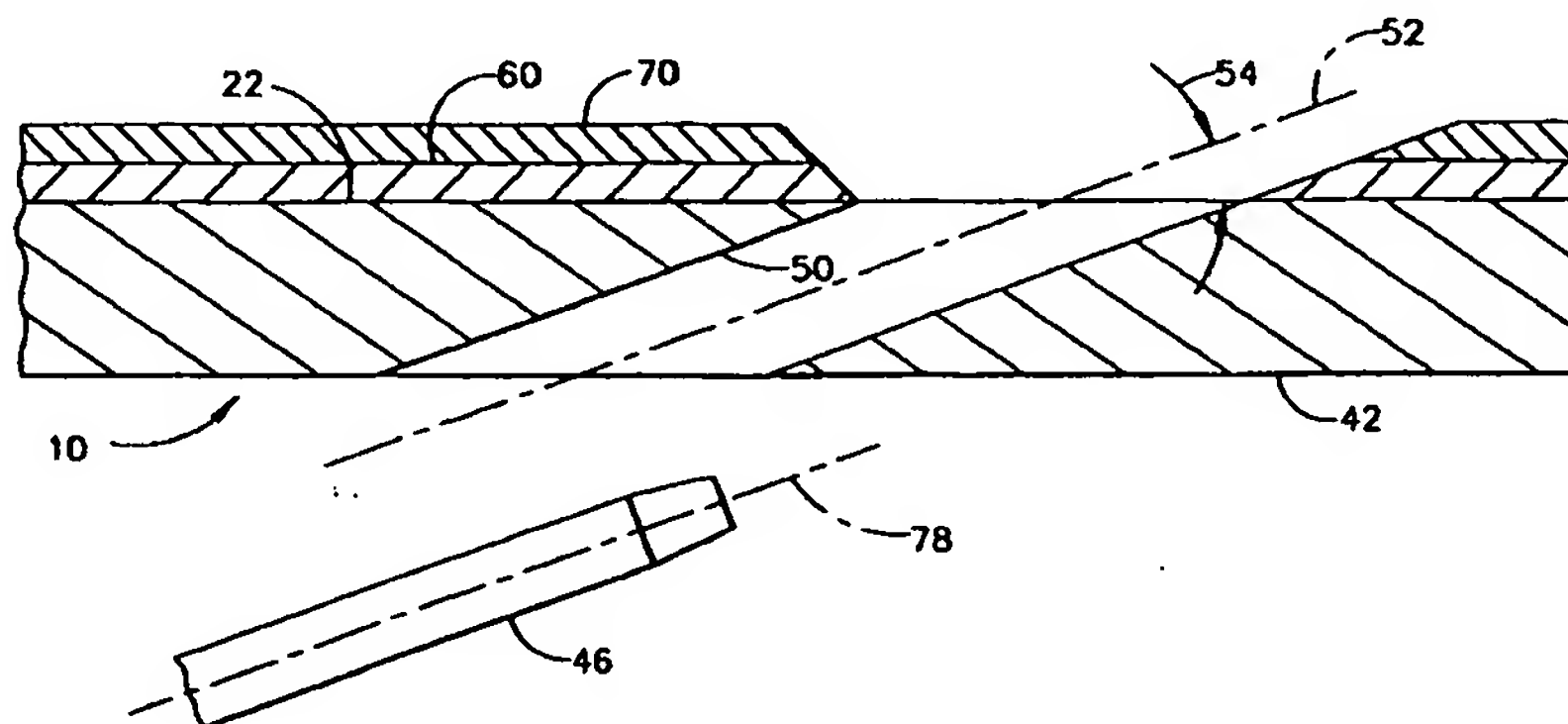
(74) Representative: Pedder, James Cuthbert et al  
GE London Patent Operation,  
Essex House,  
12/13 Essex Street  
London WC2R 3AA (GB)

(72) Inventors:  
• Farmer, Gilbert  
Cincinnati, Ohio 45239 (US)  
• Scheidt, Wilbur Douglas  
Cincinnati, Ohio 45233 (US)

**(54) Method for thermal barrier coating**

(57) A method of applying thermal barrier coating systems to a metal piece (10) having a cooling hole extending along a central axis (52) through the piece from a first surface (22) of the piece (10) to a second surface (42) of the piece (10) opposite the first surface (22). The method includes spraying a bond coat (60) on the first surface (22) of the piece (10) and spraying a thermal

barrier coating (70) on the bond coat (60). Further, the method includes spraying a high pressure fluid jet from a nozzle (46) toward the hole and in a direction generally parallel to the central axis (52) of the hole. The fluid jet is substantially free of solid particulate thereby permitting the jet to remove the bond coat (60) and the thermal barrier coating (70) from the hole without removing metal from the piece (10).



**FIG. 6**

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# EUROPEAN SEARCH REPORT

Application Number  
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The present search report has been drawn up for all claims			
Place of search MUNICH		Date of completion of the search 28 October 2002	Examiner Joffreau, P-0
<p>CATEGORY OF CITED DOCUMENTS</p> <p>X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document</p> <p>T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons &amp; : member of the same patent family, corresponding document</p>			

EPO FORM 1503 03/82 (P04C01)

**ANNEX TO THE EUROPEAN SEARCH REPORT  
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